

Date: Wednesday, 13/08/2008 10:55:26 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE ARM
Job Number	: 41213		
Estimate Number	: 13440		
P.O. Number	:	Part Number	: PB6743001343
This Issue	: 13/08/2008 S.O. No. :	Drawing Number	: B6743001 P.34
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B1
Previous Run	: 40297	Material	:
Written By	:	Due Date	: 15/09/2008
Checked & Approved By	: <u>JD 08 8 13</u>	Qty:	10 Um: Each
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 3.6750 f(s)/Unit Total : 22.0500 f(s)

6061T6 TUBE

BATCH: M108961

SAD 08/09/24

(10)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- cut to 42.00" → SAD 08/09/24 10  
 2- bend as per dwg → FF 08/09/24 10  
 3- cut to finish size as per dwg  
 4- deburr

SAD 08.09.25 10

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SAD 08/09/25 (10)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:55:26 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ARM

Job Number: 41213

Part Number: PB6743001343

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 246

8/9/05

sl

10x

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-09-26

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**RELEASED**

**-271 DOUBLER**  
MATERIAL: .125 THK, 6061-T6, QQ-A-250/11  
SCALE 2.000

**-125 CLEVIS**  
MATERIAL: 1.00 RND, 6061-T6, QQ-A-200/8  
SCALE 2.000

**-343 TUBE ARM**  
MATERIAL: 1.00 O/D X .065 WALL 6061-T6 TUBE  
WF-T-700/F6  
SCALE 0.200

**-267 PAD ATTACHMENT FIXTURE**  
MATERIAL: .032 THK 2024-T3, QQ-A-250/14  
SCALE 1.000

**-121 SQUARE SLEEVE**  
MATERIAL: 1.25 SQ, 7075-T6, QQ-A-200/11  
SCALE 1.000

The technical drawing consists of five separate views of aircraft components, each labeled with a circled number and a title. Part 1, '-271 DOUBLER', shows a rectangular plate with a central hole, dimensions like 1.00, .50, 1.50, 3.00, and a material spec of .125 THK, 6061-T6, QQ-A-250/11 at scale 2.000. Part 2, '-125 CLEVIS', shows a clevis pin assembly with dimensions such as 2.10, .85, .75, .44, .880 O.D., and a material spec of 1.00 RND, 6061-T6, QQ-A-200/8 at scale 2.000. Part 3, '-343 TUBE ARM', shows a long tube arm with a bent section, dimensions like 36.28, 1.70, 1.12, 149.0°, and a material spec of 1.00 O/D X .065 WALL 6061-T6 TUBE WF-T-700/F6 at scale 0.200. Part 4, '-267 PAD ATTACHMENT FIXTURE', shows a complex bracket-like fixture with multiple holes and slots, dimensions like 11.00, 8.62, 1.50, 1.68, 1.03, and a material spec of .032 THK 2024-T3, QQ-A-250/14 at scale 1.000. Part 5, '-121 SQUARE SLEEVE', shows a square sleeve with internal features, dimensions like 2.75, 1.25, 1.00, 1.37, .51, and a material spec of 1.25 SQ, 7075-T6, QQ-A-200/11 at scale 1.000. A circular detail view of a hole is also shown with a diameter of 1.00 REF.

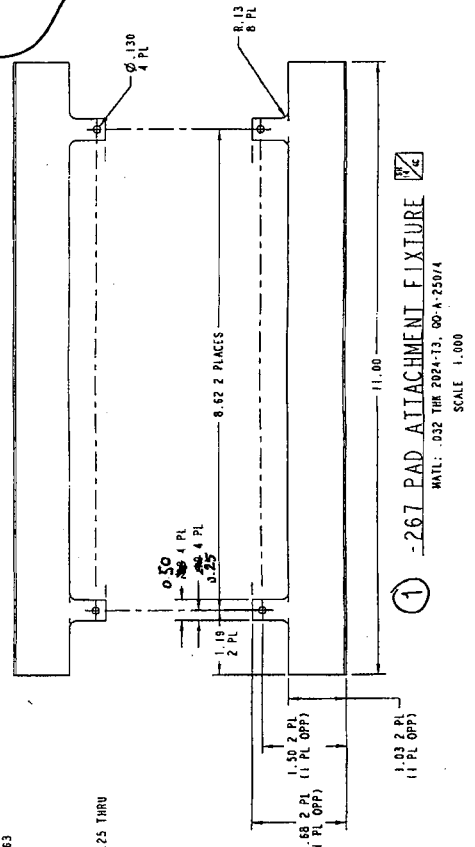
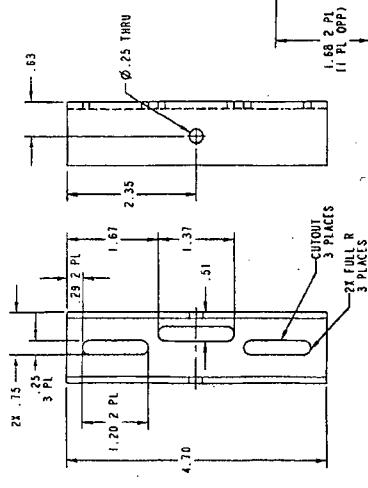
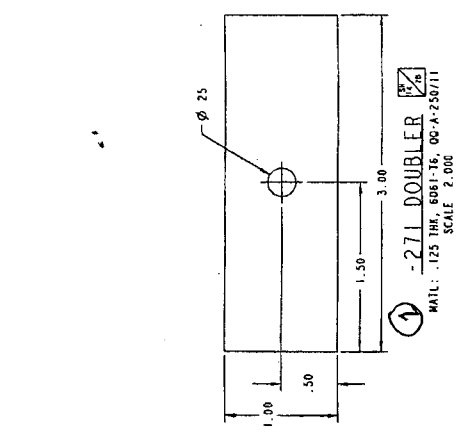
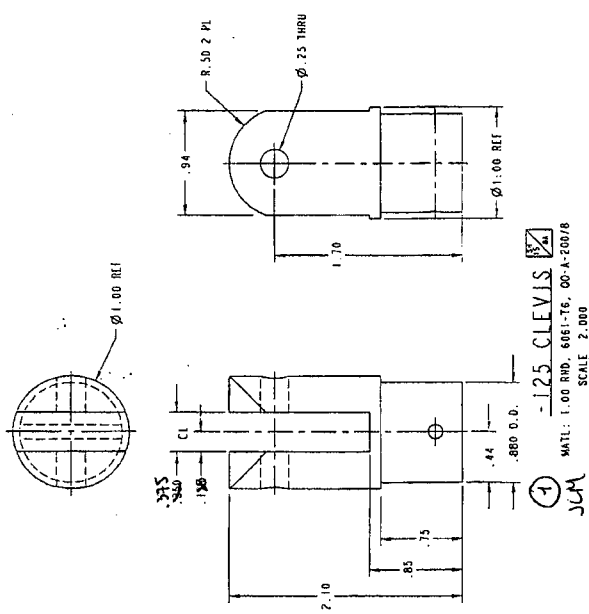
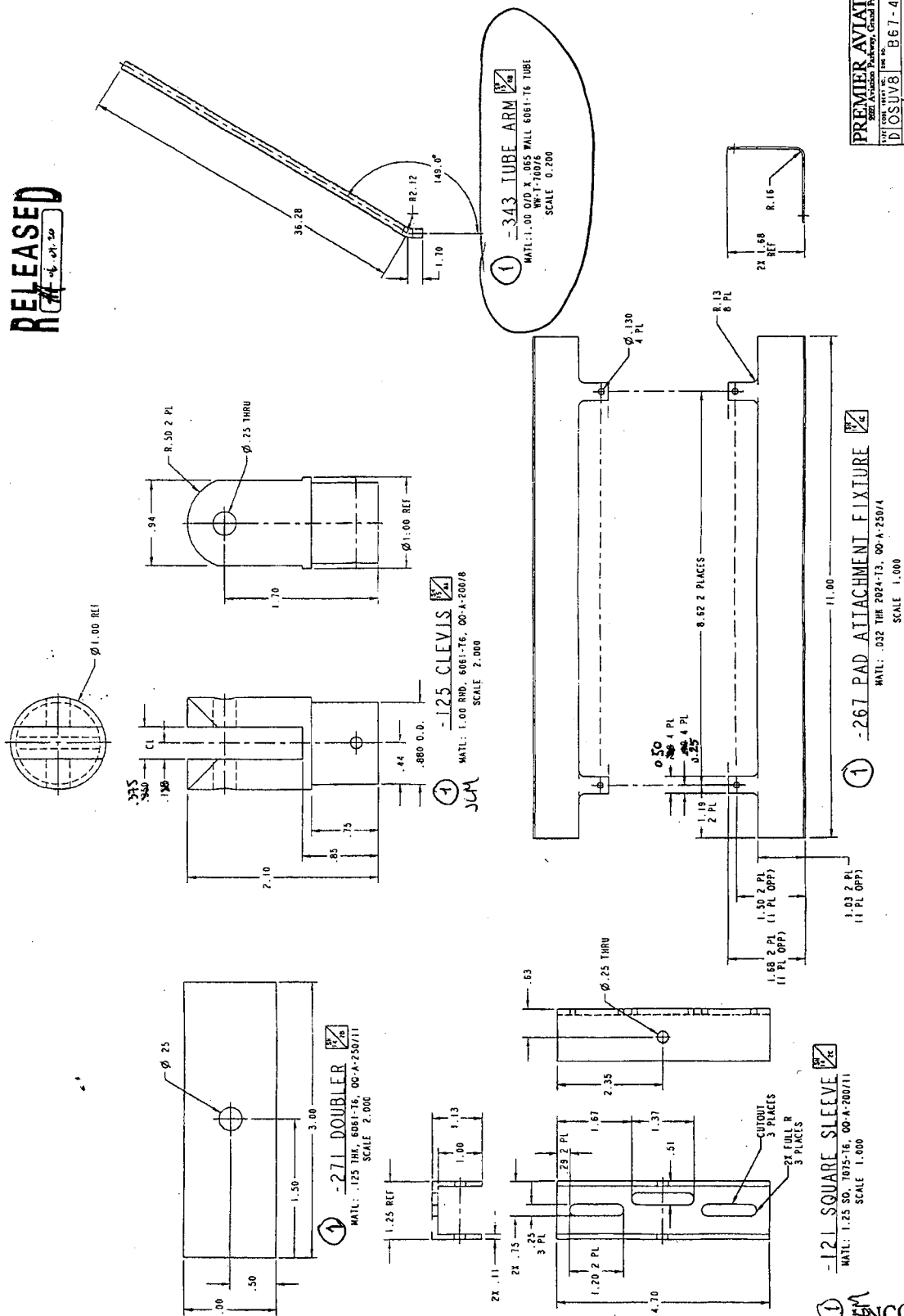
PART NO.	TITLE	MATERIAL	SCALE
1	-271 DOUBLER	.125 THK, 6061-T6, QQ-A-250/11	2.000
2	-125 CLEVIS	1.00 RND, 6061-T6, QQ-A-200/8	2.000
3	-343 TUBE ARM	1.00 O/D X .065 WALL 6061-T6 TUBE WF-T-700/F6	0.200
4	-267 PAD ATTACHMENT FIXTURE	.032 THK 2024-T3, QQ-A-250/14	1.000
5	-121 SQUARE SLEEVE	1.25 SQ, 7075-T6, QQ-A-200/11	1.000

PREMIER AVIATION, INC.  
2000 Aviation Parkway, Grand Prairie, Texas 75048

DRAWN BY: JCH DATE: 11/11/80  
CHECKED BY: BMT DATE: 11/11/80  
APPROVED BY: [Signature] DATE: 11/11/80

FIGURE 31 OF 45

ORIGINAL



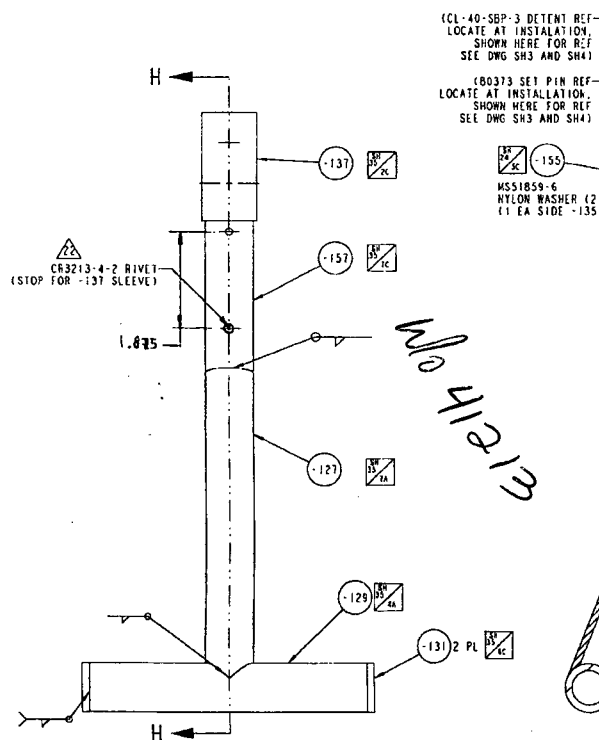
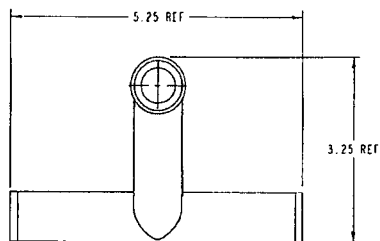
<b>PREMIER AVIATION, INC.</b>	
2822 Aviation Parkway, Grand Prairie, Texas 76058	
UNIT CON. THIS V. ONE AD.	97.
DLOSUC8	B67 - 43001
DATE: 34	OR 45
<b>ORIGINAL</b>	

1	2
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ORIGINAL

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
JECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
47213

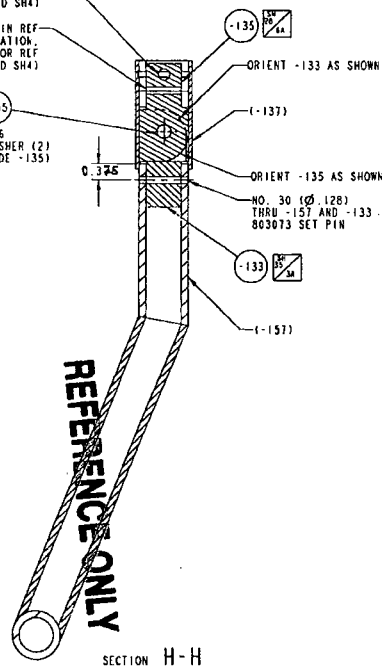


① -63 SHORT T-HANDLE ASSEMBLY  
SCALE 1.000

(CL-40-SGP-3 DETENT REF  
LOCATE AT INSTALLATION  
SHOWN HERE FOR REF  
SEE DWG SH3 AND SH4)

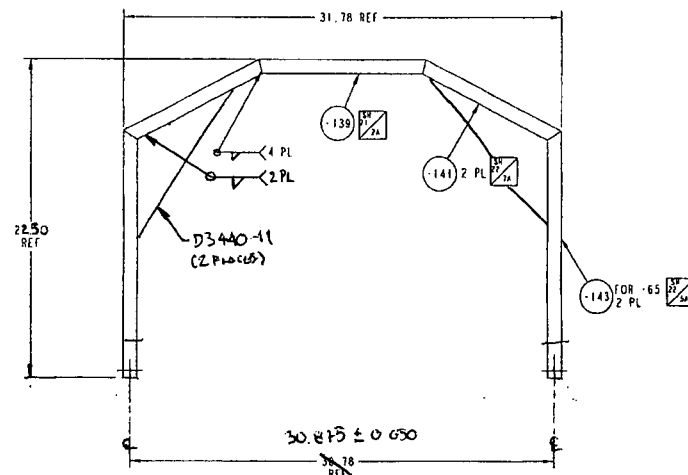
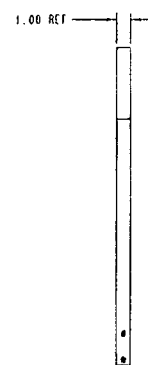
(80373 SET PIN REF  
LOCATE AT INSTALLATION  
SHOWN HERE FOR REF  
SEE DWG SH3 AND SH4)

MSS1859-6  
NYLON WASHER (2)  
(1 EA SIDE -135)



REFERENCE ONLY

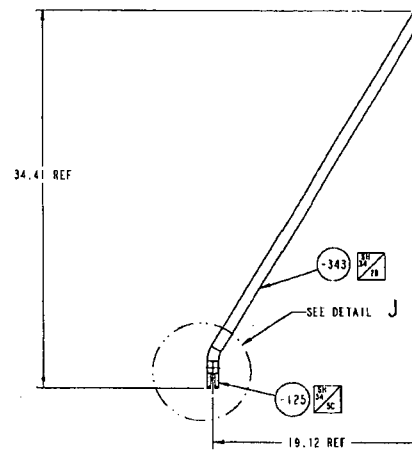
SECTION H-H



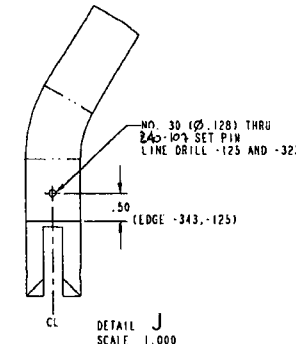
RELEASED  
06.01.20

-63 BASE ASSEMBLY (SHOWN)  
(COMMERCIAL VERSION)  
SCALE 0.250

-47 BASE ASSEMBLY (SAME, EXCEPT AS SHOWN)  
(CANADIAN VERSION)



① -37 TUBE ARM ASSEMBLY  
SCALE 0.200



DETAIL J  
SCALE 1.000

PREMIER AVIATION, INC.  
3000 Aviation Parkway, Grand Prairie, Texas 75050

SIZE	CORE	REV	NO.	REV
D	OSUV8	B67-43001	81	

ORIGINAL